

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024701**Date Inspected:** 13-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. SHI LIE**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna Pillai was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the side plate to bottom plate weld joint located on CB-19 at Panel Point (PP-125) @ north side. The weld is designated as CB3003A-019-001. The welder is identified as 054467. ZPMC QC Mr. LI YANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2214-TC-U4b-FCM-1. Further weld detail mention in attached picture.

ZPMC welding personnel performing Shielded Metal Arc Welding of built-up Repair weld for the I-rib located on 14W at cross beam side @ west side of 14W. The welder is identified as 067039. ZPMC QC Mr. AN QING XING was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing

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in compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1. The weld repair report number is named as WR-21258.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the bottom plate I-rib splice weld located on 13AE. The weld is designated as SA3035D-001-007. The welder is identified as 055564. ZPMC QC Mr. WANG LI YANG was onsite monitoring the welding variables. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2231-ESAB.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the cross beam weld joint located on CB-18. The weld is designated as CB3002A-018-016. The welder is identified as 200066. ZPMC QC Mr. LI YANG was onsite monitoring the welding variables. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2232-ESAB.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the cross beam weld joint located on CB-18. The weld is designated as CB3002A-018-020. The welder is identified as 221146. ZPMC QC Mr. LI YANG was onsite monitoring the welding variables. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2232-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By: Pillai,Santosh

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer